

## CLAIMS

1. A consumable electrode arc welding method in which two or more wires are fed and energized in a torch and the torch is moved in the welding preceding direction to thereby form weld beads for welding, comprising:

a first step of stopping the feeding and energization of all wires except for a specified wire of the two or more wires at a welding termination position; and

a second step of moving the torch a given amount from the welding termination position to a position existing not only in the opposite direction to the welding preceding direction but also in a direction allowing the torch to part apart from the weld beads.

2. A consumable electrode arc welding method as set forth in Claim 1, further including a third step of moving the torch substantially parallel with the weld beads in the welding proceeding direction from the position of the torch moved in the second step.

3. A consumable electrode arc welding method as set forth in Claim 1 or 2, wherein a wire to be specified in a torch is a wire positioned so as to move most precedingly in the torch when moving the torch in the welding proceeding direction.

4. A consumable electrode arc welding method as set forth in any one of Claims 1 to 3, wherein, in the second and third steps, using the wire specified in the torch, welding is executed under a welding termination time welding condition different from a welding condition used until then.

5. A consumable electrode arc welding method as set forth in Claim 4, wherein, in the second and third steps, a crater processing welding for filling in a crater formed in a welding termination portion is executed under the welding termination time welding condition.

6. A consumable electrode arc welding method as set forth in any one of Claims 2 to 5, further including: a fourth step of stopping the feeding and energization of

the wires at the position of the torch moved in the third step; a fifth step of checking all wires for deposition on the weld beads; and, a sixth step of, when a deposited wire is detected in the fifth step, resuming energization on at least the deposition detected wire.

- 5                    7.            A consumable electrode arc welding method in which two or more wires are fed and energized in a torch and the torch is moved in the welding preceding direction to thereby form weld beads for welding, comprising: a step of stopping the feeding and energization of the wires at a welding termination position; a step of checking all wires for deposition on the weld beads; and, a step of, when a deposited wire is detected, resuming
- 10 energization on at least the deposition detected wire.